Work Orde	er ID 96395 10:24:37 AM		*963	395*						Page 1
Item ID: Revision ID: Item Name:	D2932-2 Saddle RH Out, 206		Accept	*N900	040	100)* s	Setup Star	171	S1*
Start Date: Required Date: Reference:	2/11/13 Start Qty: 4.0	•		Cust Item I Customer:	D:					. 17
Approvals:	Process Plan: MLJ QC:				ate:		ŀ	Run Stai Sto	171	R1* R2*
Sequence ID/ Work Center I	Operation D Description	,	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D2932	Rev C									
*100 *100* HAAS 1	HAAS CNC VERT	FICAL MACHINING #1	0.00				<u> </u>	4		DAS 25 13-3-2
HAAS CNC vertica	Il machine #1 Progra numbe inspec	or m part number and batch number are programmed correctly.2-t as per dwg D2932 & attached to and visually inspect as per	Machine Step No 1 of Fol	io and visually						
110			0.00							(DASH
110	CONVENTIONAL	. MILLING MACHINE					Y	مع		25,133,26
· Mill Conv Conventional Millin	Memong Machine Machi	o ine Keyway and inspect per atta	0.00 sched dimension sheet							
120	QC1- Inspect dime	ensions to dimension sheet	0.00							(DAG)
120	Memo		0.00				4			£ 313-3-21

Quality Control

NCR:	Yes	/ No				WORK ORDER NON-		NFORM	MANCE / UPI	DATE					
											QA	Closed:	Da	ate:	
Work Ord	er:					DISPOSITION				AGAINST DI	_	RTMENT/			
Part I						Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update		Initial	Act	ion	S	ign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	ription	.	Date	Verification	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													•		
					·	F	AUL	LT CATE	GORY						
Landi		Bending Centre No Cracks Crushed/Cuffs			D/S	General Bend BOM/Route Broken/Damaged Burrs Contamination		-1	ion Incomplete ions Incomplete/U	Jnclear	Ove Par Par	alized er/Under t Incorrec t Lost/Mis t Moved	:t		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Heat Trea Inspection Ripples in	n Strip in	Tube		Countersink Cut Too Short Drill Holes		Mislabe Misread Offset	eled		Pos	sitioned W wer Loss/S	-		Other
		Torque W	/aves in E	xtrusion	1 <u> </u>	Drawing		Out of (Calibration						

Out of Sequence

Outside Dimensions

DQA: Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord January-28-13				*963	395*				Page 2
Item ID: Revision ID: Item Name:	D2932-2 Saddle RH O		<u> </u>	Accept	*N9000	04010	n * ⁵	Setup Star Stop	14.21
Start Date: Required Date Reference:	2/11/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:	: .			ואיט
Approvals:		lan:		Tooling: SPC (Y/N):	Date			Run Star Stop	"NH1"
Sequence ID/ Work Center I		Operation Description QC8- Inspect parts - sec	ond check	Set Up/ Run Hours	Tool ID mf 13/03	Tool # Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
130 QC Quality Control		Memo		0.00	~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~	724		B	
		Chemical Conversion Co	oat per QSI005 4.1	0.00			4	rlb.	13378
HandFinish Hand Finishing		Мето		0.00					
150		White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00			1 //	1	n 1 12/11
150 Powder Coating		Memo START TIM	ME: 3-2		B:		42	g m	nd 13/24/
140 *140* HandFinish Hand Finishing 150 *150* Powdercoat Powder Coating	10116	Memo White Gloss(Ref:4.3.5.1 Memo START TIM) per QSI005 4.3-Alum 3 ~2	0.00	∃:				

M124245

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	100	VFOR	MANCE / UP	DATE		1	
											QA Closed:	Date:	,
Manta Ond						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Ord	er.					Rework	7		Skid-tube	Crosstube]	Water Jet	Engineering
Part	Nο					Scrap	1		Machining	Small Fab	Pro:	d. Eng. Coor.	Quality
1 410	110.					Use-as-is	1		noforming	Finishing	4	re/Packaging	Other
NCR	No.					Work Order Update	1		Large Fab	Composite		Supplier	
						· •							•
Root					Descri	iption of work order update		Initial	Ac	tion	Sign &	1	
Cause		Date	Step	Qty		or Non-conformance	Cr	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												1	
Equip/Tooling												1 • 1	
Operator													
Material												1	
Setup												0	
Other			1										
Process		1					1					ı	
Supplier	Г	1					Ì						
Training	Г	1										'	
Unapproved		1			8-							1	
			•			F	AUI	T CATE	GORY				
Land	ing (Gear		·		General		_			_		
		Bending				Bend		Grain			Ovalized	1	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route] Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
1		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Work Orde				*963	395*							Page 3
Item ID: Revision ID: Item Name:	D2932-2 Saddle R	P. Out, 206		Accept	*N900	040	100)* s	Setup	Start Stop	1.7	S1* S2*
Start Date: Required Date: Reference:	2/11/13 2/11/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item : Customer:	ID:						
Approvals:	Process QC:	s Plan:	Date:	Tooling: SPC (Y/N):		ate:		F	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 160 *160* QC Quality Control)	Operation Description QC3- Inspect Part Finish Memo	1	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qt	y 1	Reject Number	Insp. Stamp - (3/0 t/0
170 Packaging Packaging		ldentify as per dwg & St Memo	ock Location:	0.00						<u>/</u>) by/2	4
180		QC21- Final Inspection	- Work Order Release	0.00							/	do

0.00

Memo

120

Quality Control

13/4/3/D

										DQA:	Date	,
NCR: Y	'es / No				WORK ORDER NON-	CON	FORN	MANCE / UP	DATE	QA Closed:	Date	
									A CAMET DE		1	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
	10.				Rework Scrap Use-as-is		ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	l	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update]		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	ln	itial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		1										
Equip/Tooling												
Operator		1										
Material											:	
Setup								. •				
Other											1	
Process			1								1	
Supplier												
Training											1	
Unapproved		1				<u> </u>				<u> </u>		
						AULT	CATE	GORY			·	
Landi	ng Gear				General					1		Pressure/Forced
	Bending			, <u> </u>	Bend	-	Grain		ļ	Ovalized	A-1	
	Centre N	ot Conce	ntric to ()/5	BOM/Route		Hardwa		<u> </u>	Over/Under Part Incorre		Temperature/Cure Weld
	Cracks	/o · I		-	Broken/Damaged	-		on Incomplete	l la ala a a	-1	<u> </u>	Wrong Stock Pulled
	Crushed/	Crimped	-	-	Burrs			ions Incomplete/	Unclear	Part Lost/Mi Part Moved	ssing [
	Cuffs			<u> </u>	Countarink	-	Mainte Mislabe		-	Positioned V	(rong	
	Heat Trea		T l		Countersink	\vdash			-	Positioned v	_	Other
	Inspectio	•	rupe	-	Cut Too Short	-	Misreac Offset	•	<u> </u>	Trower ross/	ouige	Tottlet
	Ripples in				Drill Holes	\vdash		Calibration				
	Torque V	vaves in t	extrusion	1	Drawing	1 10	JUL OF (Calibration			1	

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

January-28-13 10:24:36 AM

Work Order ID:

96395

Parent Item:

D2932-2

Parent Item Name:

Saddle RH Out, 206

Start Date: 2/11/13

Required Date: 2/11/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP: B00.06.26New DWG rev (mpp 2069)EC

IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	50.0000	1	4	\$1 12	2.0/	
Saddle Billet, 7075											JL_/J-	5.76	U 75 in 100 5 1 1 1 2 1
				Location		Loc Qty	Lo	c Code					
				MAT042		50			an -				
				9484	10	50							

97563

4

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE		•	ı		
											_	QA Closed:	l Da	te:	
Work Orde	or.				-	DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
VVOIR OIG	L1.					Rework	1		Skid-tube	Crosstube	٦		Water Jet		Engineering
Part I	Vo.					Scrap	1		Machining	Small Fab	1	Proc	d. Eng. Coor.	П	Quality
		-				Use-as-is	1	Therm	noforming	Finishing	٦		e/Packaging		Other
NCR I	۷o.					Work Order Update]		Large Fab	Composite			Supplier		
			,				7	<u> </u>			-		<u> </u>		r -
Root	Ì					ption of work order update	1	Initial	i	tion		Sign &	1		
Cause .		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descr	ription ,	4	Date	Verificatio	<u>n</u>	QC Inspector
Doc/Data												j			
Equip/Tooling													ì		
Operator													1		
Material	<u> </u>												ì		
Setup													-		·
Other	<u> </u>							:					i		
Process				,								.•	1		
Supplier													'		
Training													1		
Unapproved				<u> </u>				····			┙		<u> </u>		
							AUL	T CATE	GORY		_				
Landi		1				General		1		Γ-	_		1	_	1
	_	Bending			<u> </u>	Bend	_	Grain		<u> </u> -	-	Ovalized	1	<u> </u>	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	<u> </u>	Hardwa		.		Over/Under	1	\vdash	Temperature/Cure
	\vdash	Cracks				Broken/Damaged	L	4	ion Incomplete	<u></u>	-	Part Incorred		<u></u>	Weld
	L	Crushed/	Crimped.			Burrs	_	-1	ions Incomplete/l	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		ot	Part Moved	i		
	L	Heat Trea	t			Countersink		Mislabe	led		-	Positioned V	1	_	7
		Inspection	n Strip in	Tube		Cut Too Short		Misread	.			Power Loss/	Surge	L	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

DART AEROSPACE LTD	Work Order:	96395
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

			ignica on mape	1	corded Act				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
A	0.100	0.140		-131	126	-124	124		
В	0.100	0.140		.135	126	126	124		
С	0.100	0.140		129	-120	-119	1114	1 1	
D	0.210	0.230		221	221	221	-221		
E	1.245	1.255		1250	1.250	1,250	1250		
F	1.245	1.255		1,250	1-250	1-250	1.250		
G	2.495	2.505		2.500	2-500	2.500	2.500		
Η	0.510	0.515		- 512	-512	-512	-512		
- 1	1.572	1.582		1,577	1.577	1-577	1-577		
J	2.495	2.505		2,500	2-500	2.500	2.500		
K	0.257	0.262		-258	258		-258		
L	0.312	0.317		.313	-313	258	313	†	
_ M	0.235	0.240		.236	237	237	732	-	
N	0.100	0.140		-120	.120	-120	-120		
.0	0.540	0.560		549	549	549	-549	 	
P	0.490	0.510		-501	-501	499	-500		
Q	3.715	3.725		2 720	3.720	3700	B. 720		
R	2.470	2.510		2,490	2490	2.490	2.490		
S	0.240	0.270		251	-251	251	-25		
T	0.100	0.180		130	-130	130	-130	<u> </u>	
U	1.625	1.635		1.630	1.630	1.630	7.630		
V	1.362	1.372		1.367	1-364	125	1-367		
W.	0.316	0.321		.316	-316	-316	-316		
Χ	1.125	1.145		1135	1/35	1-135 1-135	1135		
Υ	1.565	1.585		1.573	1573	1573	1531		
Z	0.178	0.198		188	-188	188	IXX		
AA						- <u> </u>	100		
AB									
AC							-4.		
AD									
AE									
AF									
AG									
АН				-				-	
	Acc	ept/Rejec	t						

Measured by: \(\frac{1}{2}\)	Audited by	مراس
Data: 12 2 2/		
Date: / ペーマン () ()	Date:	12/02/07
		12/03/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	1
С		Revised per drawing revision C	KJ/JLM Z	Cult

